

Date: Wednesday, 25/03/2009 11:53:53 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOOR ASSEMBLY, LH
<b>Job Number</b> :	45535		
<b>Estimate Number</b> :	13763		
<b>P.O. Number</b> :		<b>Part Number</b> :	D130780043
<b>This Issue</b> :	25/03/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	IIN-D130-780
<b>First Issue</b> :	05/02/2009	<b>Project Number</b> :	N/A
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	PURCHASED PARTS	<b>Due Date</b> :	28/02/2009
<b>Written By</b> :		<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b> :	JLD 09.03.25		
<b>Comment</b> :	Est Rev:A 09-02-03 new issue DD verified by:JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

for JLD 09/02/11

Photocopy bluefile and type labels per PPP D130-780-043 CHG 001

2.0	D31863	Spacepod Door, LH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door, LH

batch: B45691

090504

3.0	D24641250	Neoprene Seal
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Neoprene Seal

batch: 39669

09/04/28

4.0	D38373	Decal
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: B46232

09/04/28

5.0	D2586	Door Latch
-----	-------	------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: 45554

09/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45535

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Channel

batch: \_\_\_\_\_

45887

SS 09/04/28 (X)

7.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate, 350 Spacepod

batch: \_\_\_\_\_

41175

SS 09/04/28 (X)

8.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

M109321

SS 09/04/28 (X)

9.0

NAS1149D0363J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

M110985

NO QTY'S

090504

PTO

1

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

M110844

SS 09/04/28 (X)

11.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

41166

SS 09/04/28 (X)

12.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

B 39786

SS 09/04/28 (X)

# Dart Aerospace Ltd

W/O: 45535		ESTIMATE: 13763		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090504	9.	NAS1149 D03635 <del>should</del> <sup>will</sup> be AN960 SD10  <i>Permanent Change</i>	<i>[Signature]</i>	09/05/04		<i>[Signature]</i> 09/05/04	<i>[Signature]</i> 09/05/04	

Part No: D130-780-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45535

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2228

Bracket Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: 30679

SS 09/04/28 (X)

14.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M 104603

SS 09/04/28 (X)

15.0

NAS1149DN832J

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M111193

SS 09/04/28 (X)

16.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M110002

SS 09/04/28 (X)

17.0

D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: 32647

SS 09/04/28 (X)

18.0

D2228

Bracket Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: 30679

SS 09/04/28 (X)

19.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: 37674

SS 09/04/28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45535

Part Number: D130780043

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 NAS1149D0563J Washer



AN9605PS16  
0909/05/04  
40 per QSE 017

NO QWIS.



PTO

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

batch: M110523

AD

090504

1

21.0 D30153 Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Locknut

batch: 45394

SS 09/04/28 (X)

22.0 AN526C832R14 Screw



PTO

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M104916

SS 09/04/28 (X)

23.0 AN526C832R10 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M104603

SS 09/04/28 (X)

24.0 NAS1149DN832J Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch: M110844 x2 M111193 x2

SS 09/04/28 (X)

25.0 MS21042L08 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M110602

SS 09/04/28 (X)

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg

AD

090504

1

W/O: 45535		ESTIMATE: 13763		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090504	22.0	AN526C832 R14 is too long, change to a AN526C832 R12 <u>M107285</u> qty 2			<i>[Signature]</i>	09/05/04		<i>[Signature]</i> 09.05.04	<i>[Signature]</i> 09.05.04
090504	20-	NAS1149D05635 <del>should</del> be AN9605D516 <i>will</i>  Permanent Change			<i>[Signature]</i>	09/05/04		<i>[Signature]</i> 09.05.04	<i>[Signature]</i> 09.05.04

Part No: D130-780-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45535

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
INSPECT WORK TO CURRENT STEP

09.05.05

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PACKAGING RESOURCE #1  
pick kit:

29.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Keys, Key Chain, 350 Hinge  
Batch: B38814

09/05/06

30.0

D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Door Prop  
batch: 832644 09.02.11

50

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: 108335 09.02.11

50

32.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
batch: 110814 09.03.18

50

33.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer  
batch: 109268 09.02.11

50

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45535

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS21042L08

Nut



(K)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch:

109174 09.02.11

9/5/6

SK

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
INSPECT 100% KITS FOR COMPLETENESS

809/5/06

(K)

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-043

Location:

PPP Rev:

PPP 45459 DRAFT 24/5/6

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
FINAL INSPECTION/W/O RELEASE

09/05/07

DA

Job Completion



MF 09-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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WITHOUT NOTICE

WORK ORDER

NO. 45535

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Date: 08/10/07 AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 45535

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

\* Pre-installed on D3186-3/-4 Spacepod™ Door

\*\* Pre-installed on D3188-5/-6 Spacepod™

\*\*\* Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: **A**  
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 Date: 08:10:07  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 45535

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D3188	REV. E SHEET 1 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

**RELEASED**07.04.09 **[Signature]****GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:  
  
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
  
FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES  
  
FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

**4) MOLD SCHEDULE:**

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

- 6) FINISH INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

- 7) ALL DIMENSIONS ARE IN INCHES

- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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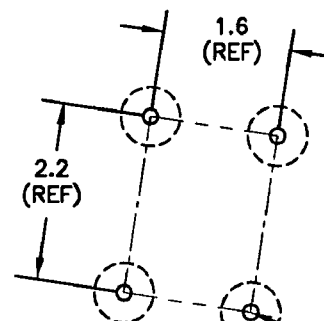
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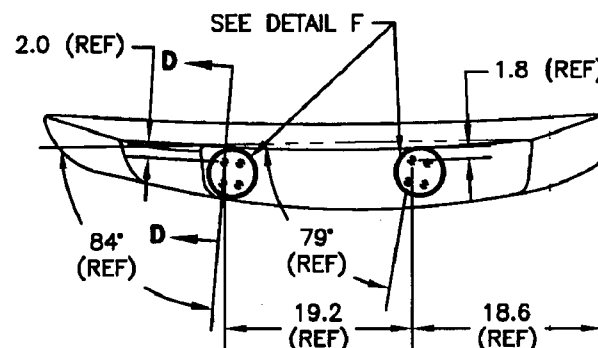
**DART**

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07-04-01

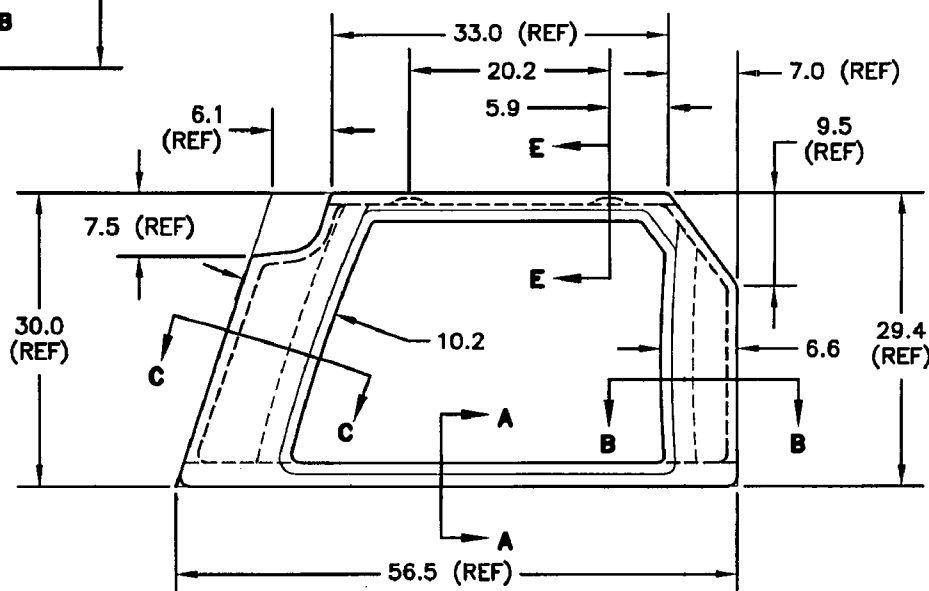
INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**DETAIL F**



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
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DATE	07.04.02	DRAWING NO.	D3188	SHEET 2 OF 11
TITLE	SPACEPOD BODY	SCALE	NTS	

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**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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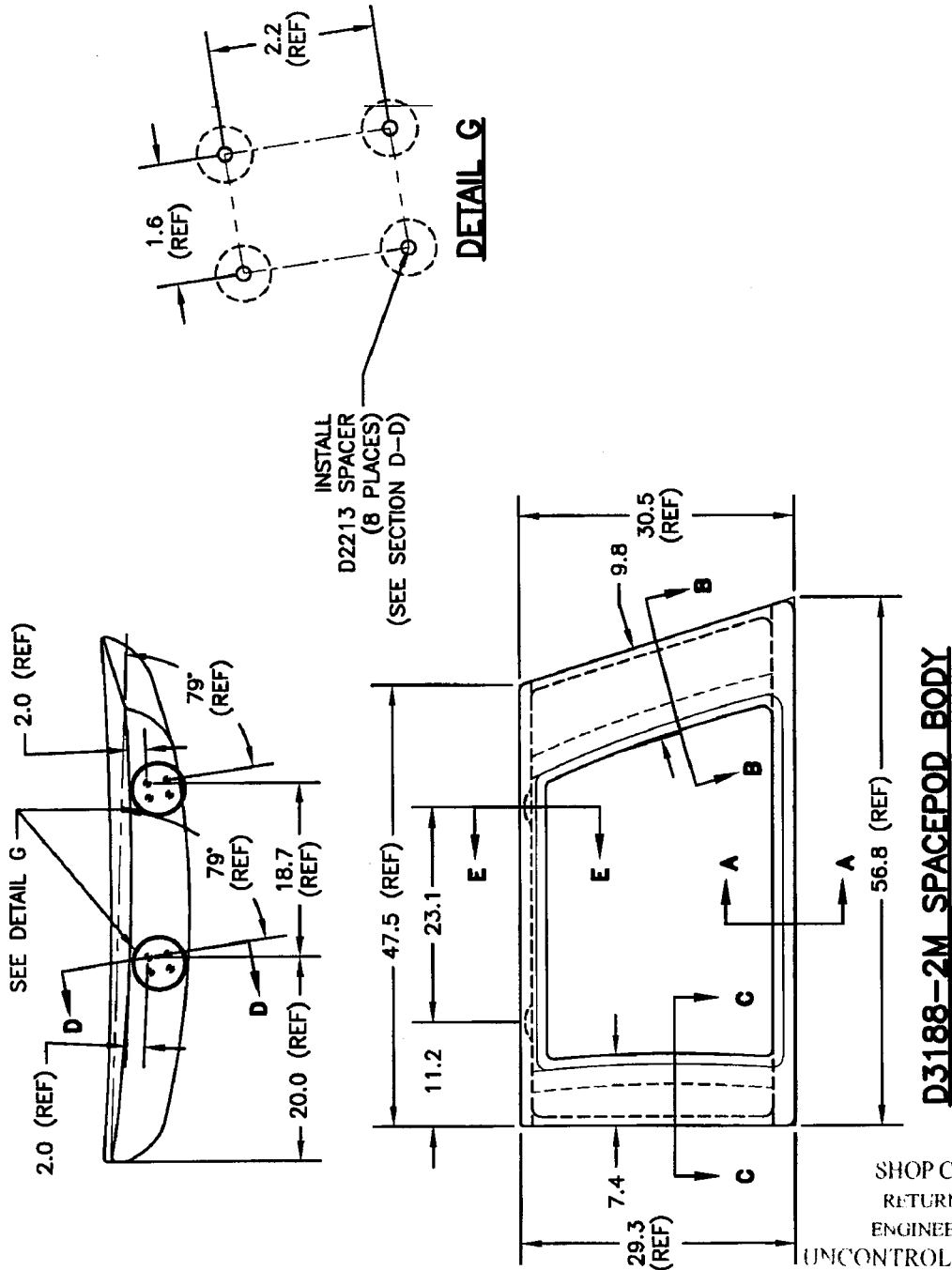
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.01



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NO. 45535

D3188-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

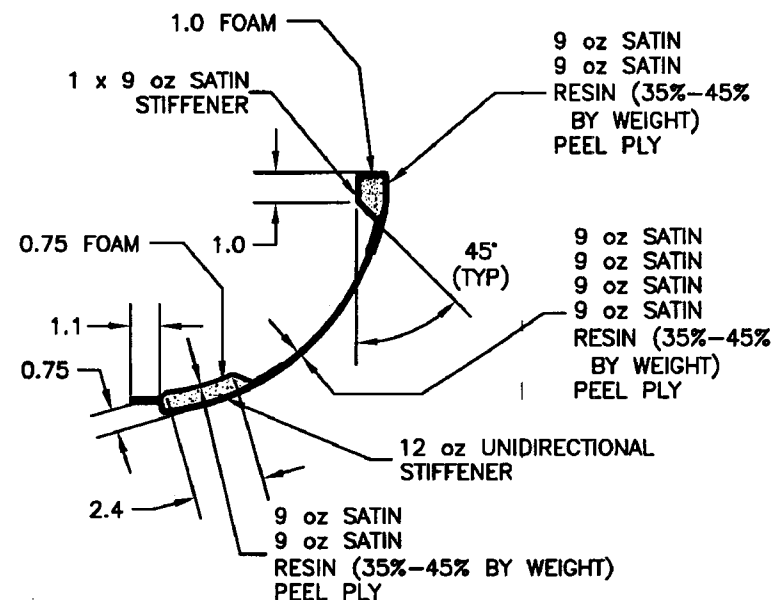
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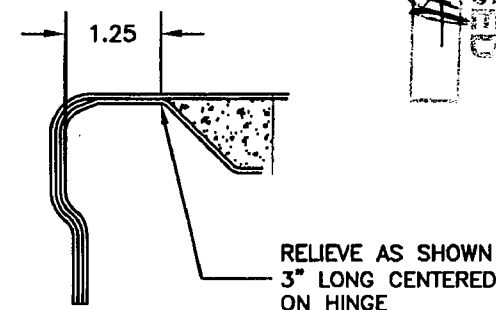
**DART**

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

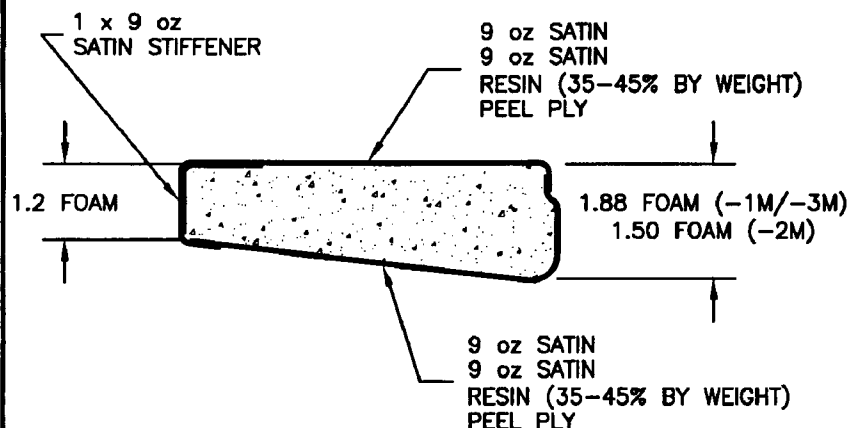
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07.04.01



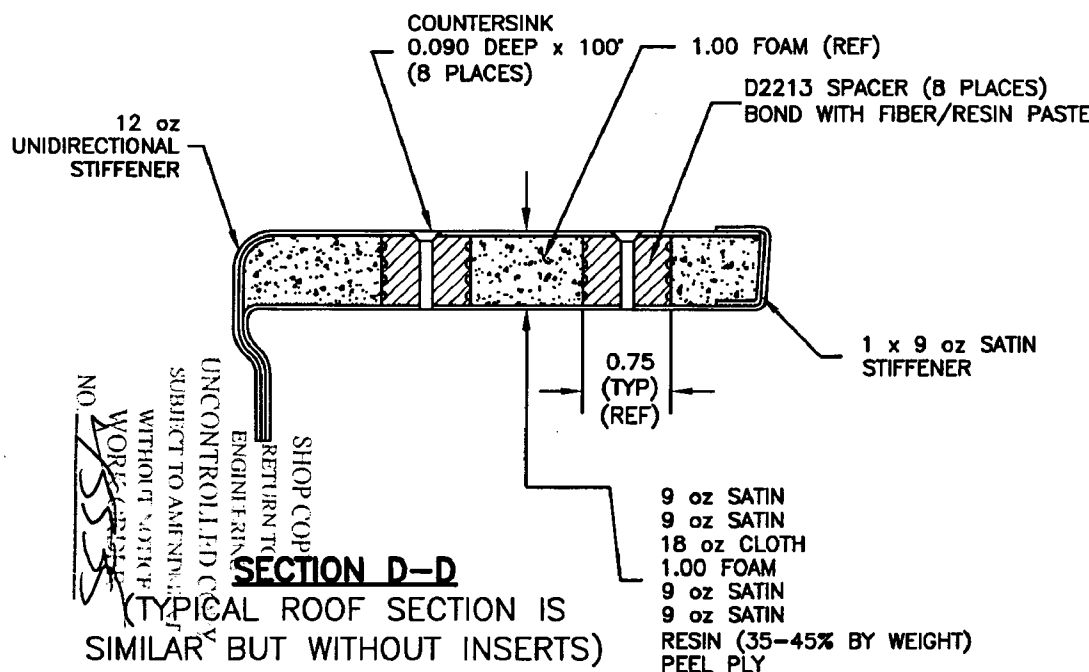
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION E-E**  
(2 PLACES PER POD)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)

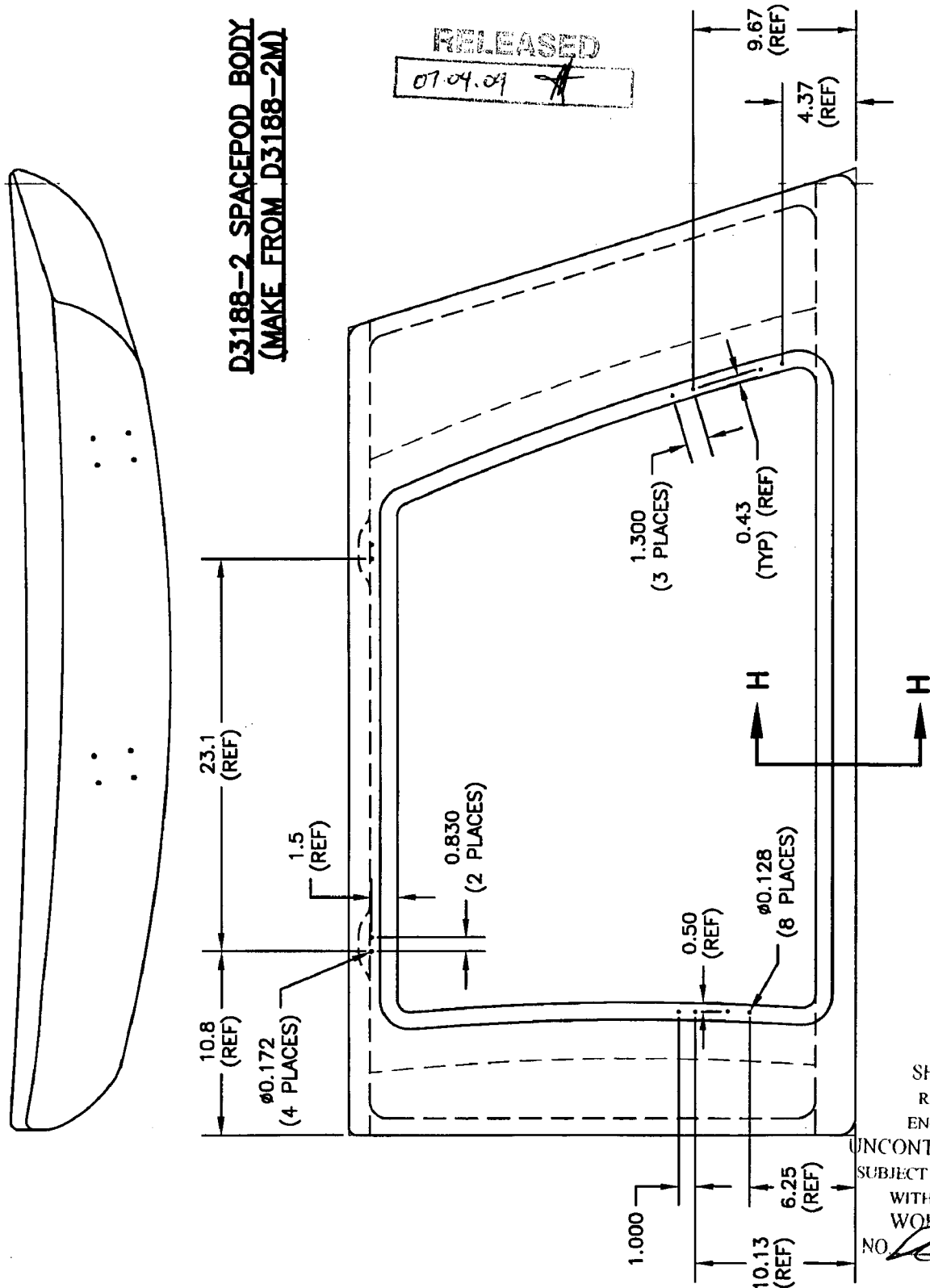


**SECTION D-D**  
(TYPICAL ROOF SECTION IS SIMILAR BUT WITHOUT INSERTS)





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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



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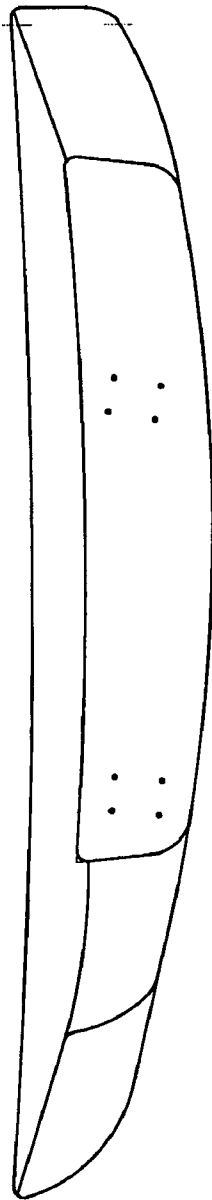
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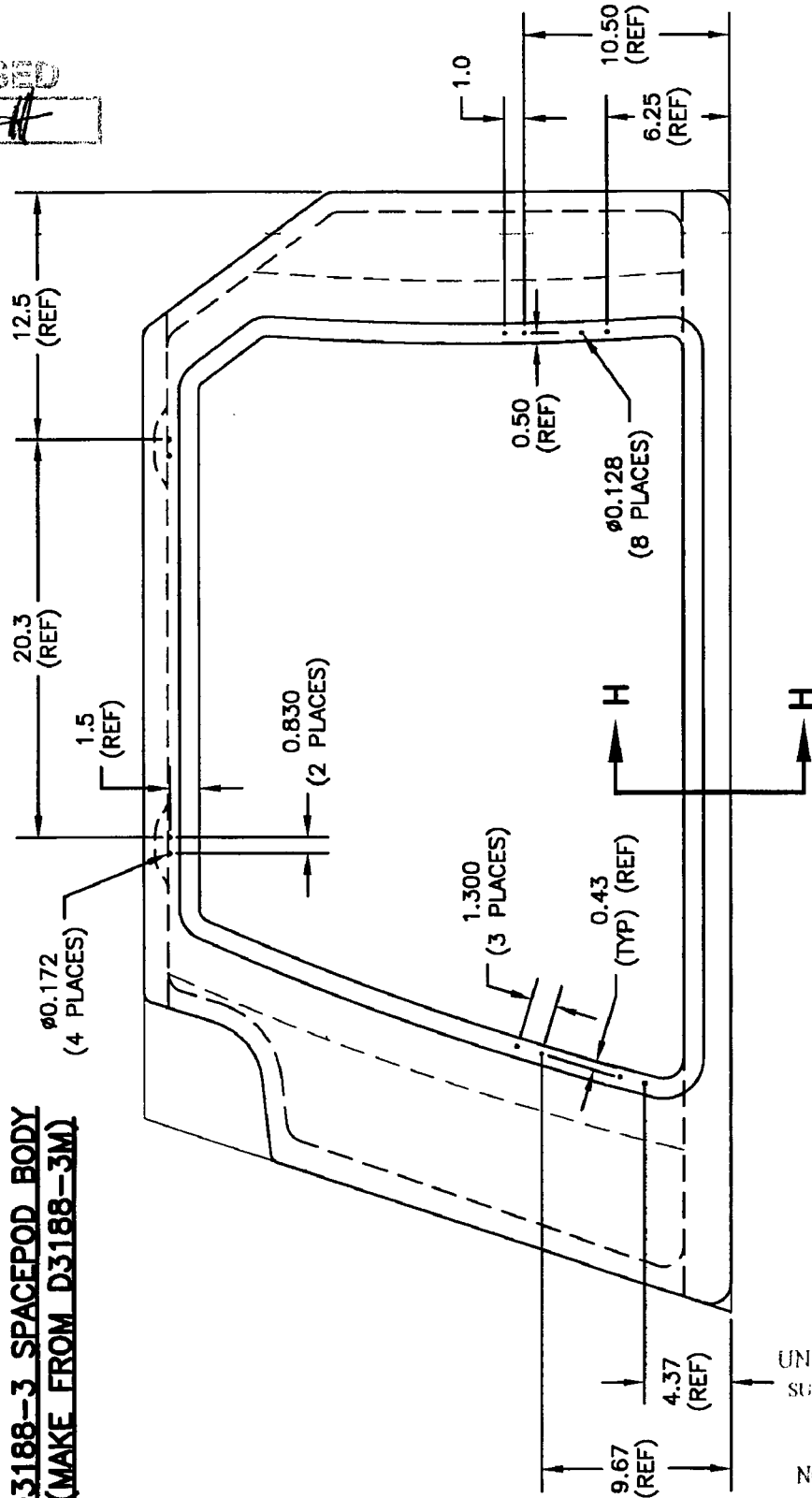
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.09



**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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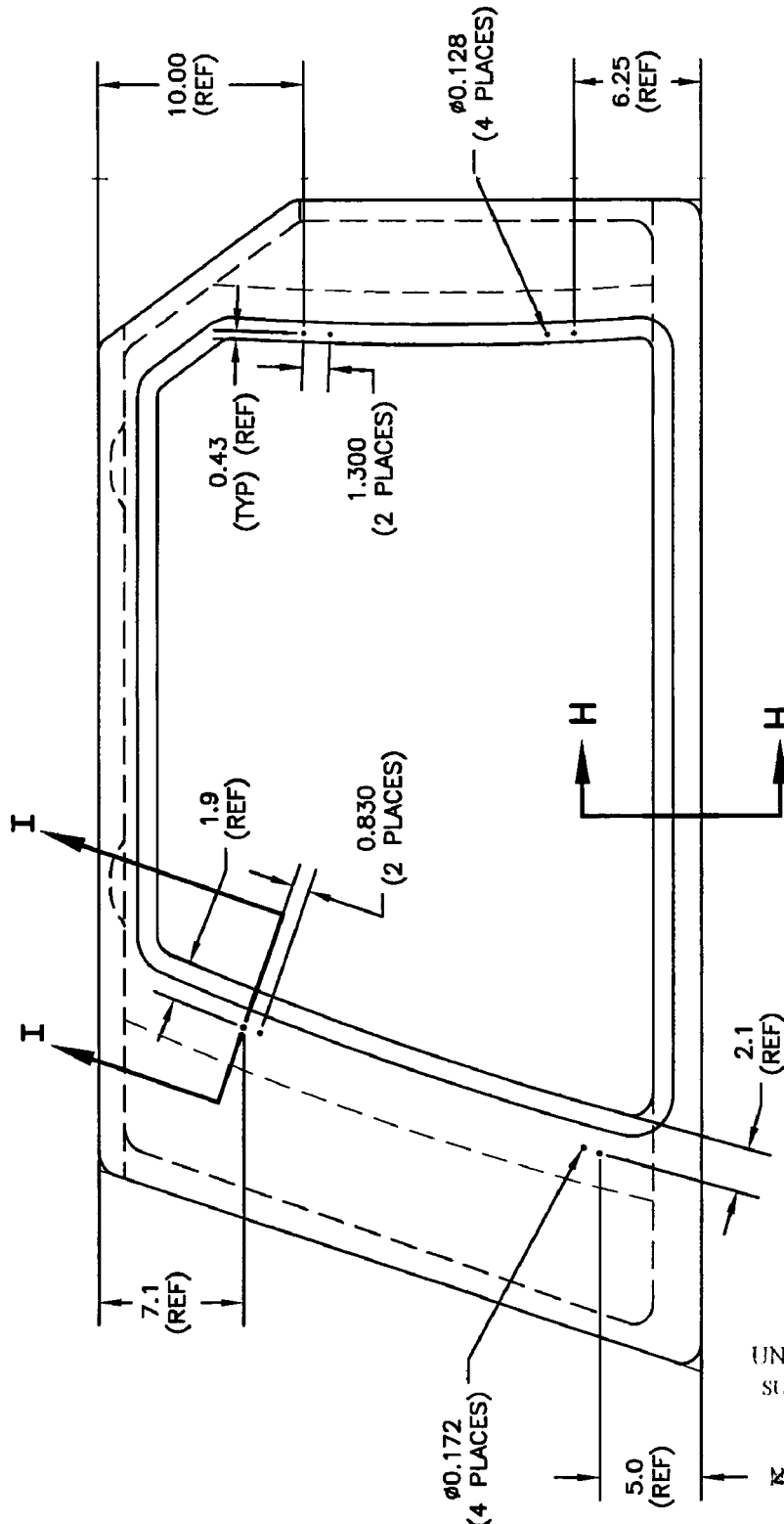
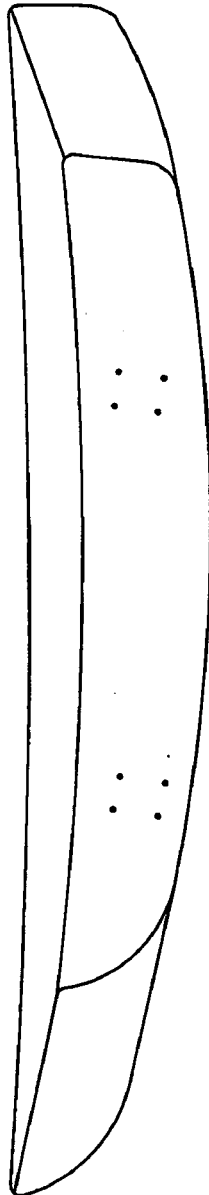
**DART**

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

**D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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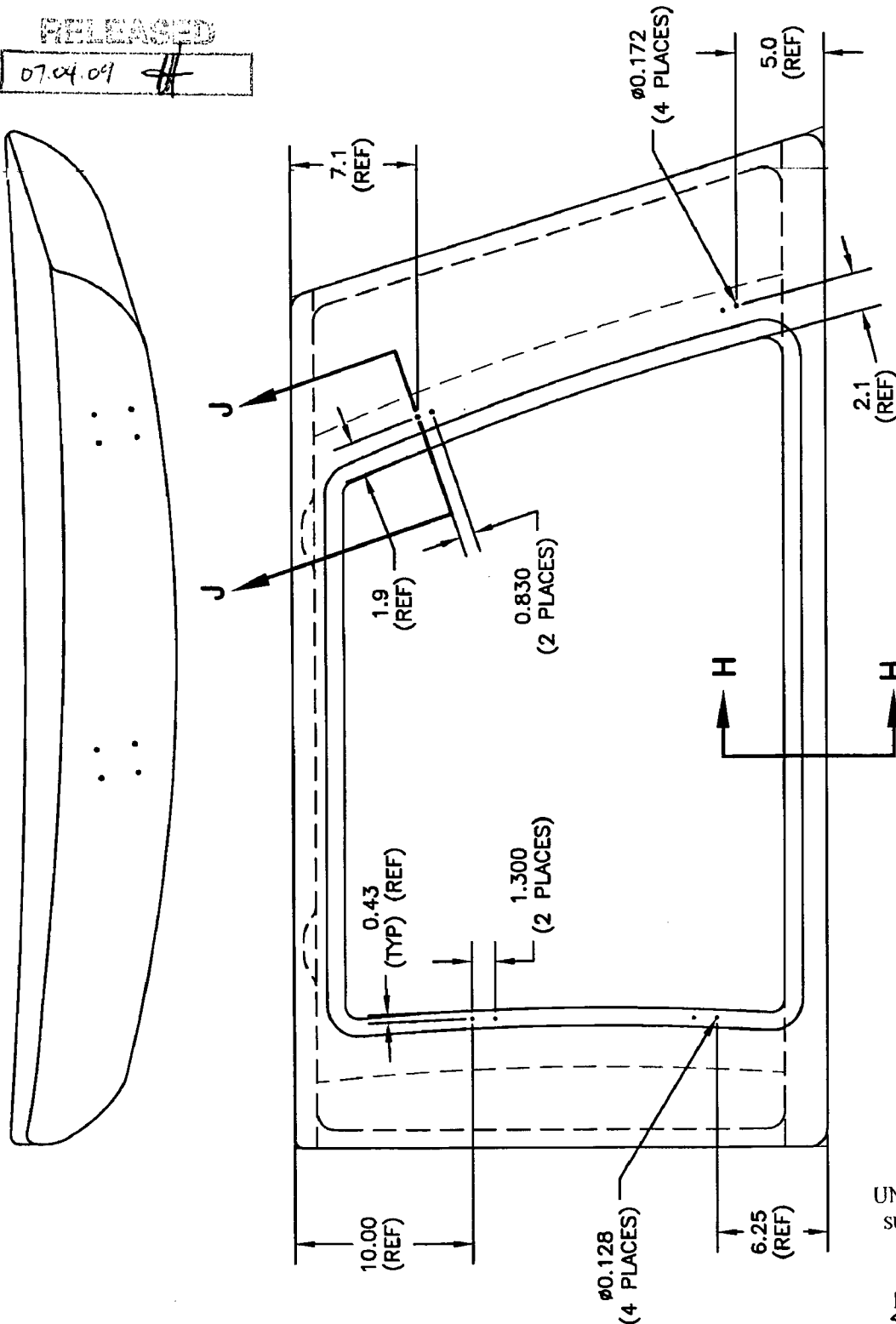
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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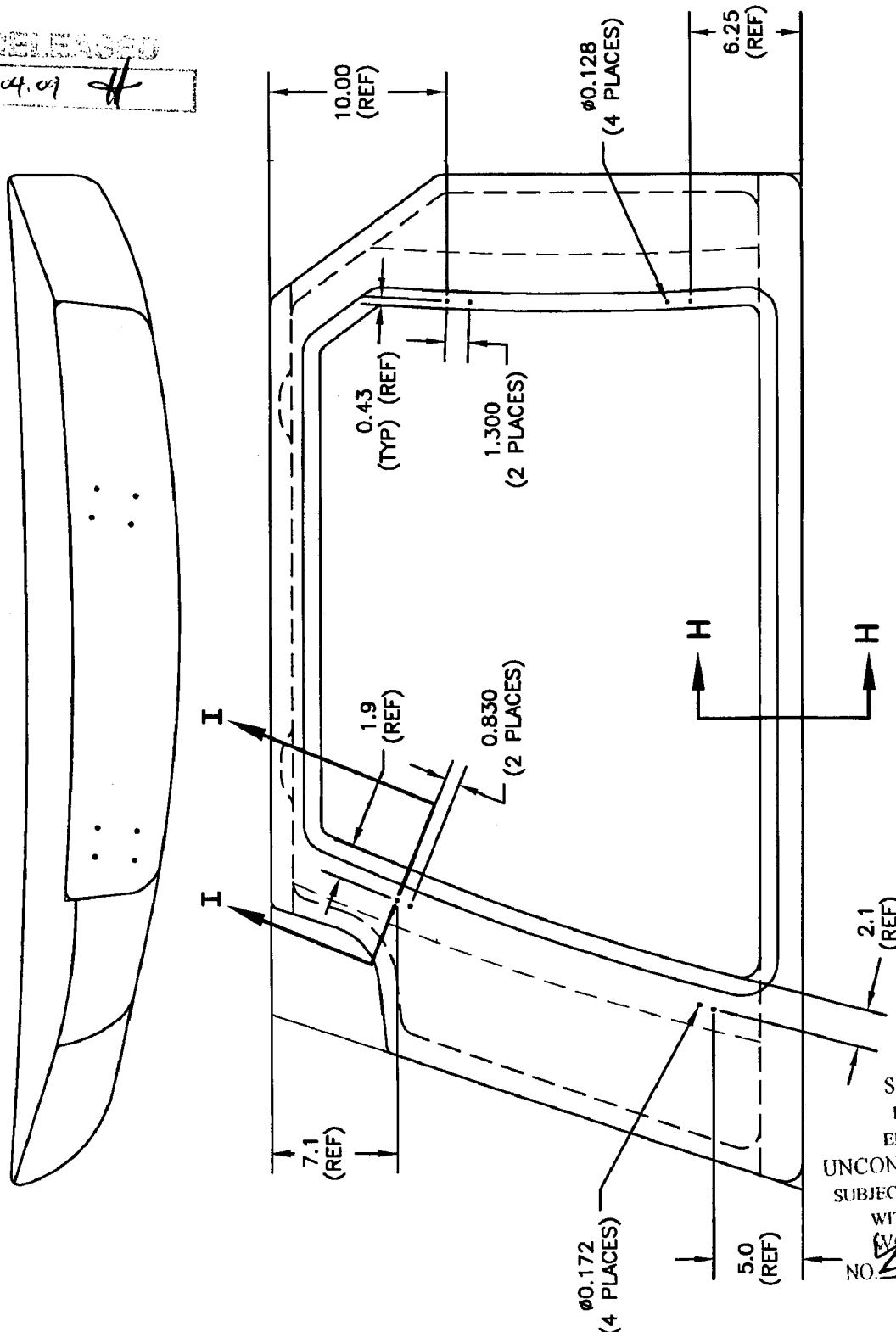
**DART**

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 H

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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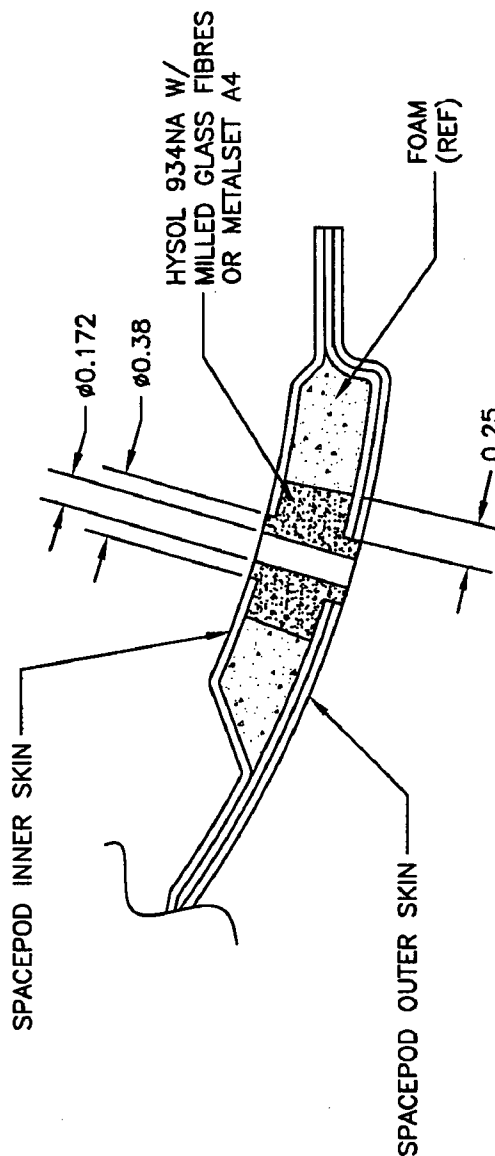
07.04.02 *[Signature]*

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Wednesday, 25/03/2009 1:32:23 PM

User: Julie Dawson

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 45535	<b>Customer</b>	: Dart Helicopters Services LLC.
<b>Estimate Number</b>	: 13763	<b>DWG Name</b>	: DOOR ASSEMBLY, LH
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D130780043
<b>Complete Date</b>	: / / : : AM	<b>DWG Number</b>	: IIN-D130-780
		<b>Rev.</b>	: A

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
28/02/2009	1	0

<b>30.0 D35527-Door Prop</b>	<b>INVENTORY ITEM</b>				
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>COST</b>	
11/02/2009	QUIR01: Quirion, Sonia	D35527	1.000	\$39.80	Lot # 32644 Qty. 1
<b>Subtotal:</b>	QTD:	0	CTD:	1	\$39.80

<b>31.0 MS270390811-Screw</b>	<b>INVENTORY ITEM</b>				
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>COST</b>	
11/02/2009	QUIR01: Quirion, Sonia	MS270390811	2.000	\$0.38	Lot # 108335 Qty. 2
<b>Subtotal:</b>	QTD:	0	CTD:	2	\$0.38

<b>32.0 NAS1149DN832J-Washer</b>	<b>INVENTORY ITEM</b>				
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>COST</b>	
18/03/2009	LAVO01: Lavoie, Chantal	NAS1149DN832J	4.000	\$0.62	Lot # 110844 Qty. 4
<b>Subtotal:</b>	QTD:	0	CTD:	4	\$0.62

<b>33.0 NAS1515H3-Washer</b>	<b>INVENTORY ITEM</b>				
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>COST</b>	
11/02/2009	QUIR01: Quirion, Sonia	NAS1515H3	2.000	\$0.38	Lot # 109268 Qty. 2
<b>Subtotal:</b>	QTD:	0	CTD:	2	\$0.38

<b>34.0 MS21042L08-Nut</b>	<b>INVENTORY ITEM</b>				
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>COST</b>	
11/02/2009	QUIR01: Quirion, Sonia	MS21042L08	2.000	\$0.64	Lot # 109174 Qty. 2
<b>Subtotal:</b>	QTD:	0	CTD:	2	\$0.64

		<b>TIME</b>	<b>COST</b>
	Machine Time:	0.00	\$0.00
	Labor:	0.00	\$0.00
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$41.82
	SUB-COMPONENT (SUB-JOB):		\$0.00
<b>Total:</b>			\$41.82

<b>COST PER UNIT:</b>	\$41.82
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